Work Orde November 10, 20												Page 1
Revision ID:	D2561 B Lug		A	Accept				s s	etup (Start Stop		
Start Date: Required Date: Reference:	11/10/09 11/13/09	Start Qty: 60.00 Req'd Qty: 60.00			Cust Item I Customer:	D:						
Approvals:	Process Pla	an:CL	Date: <u>09 0</u>			ate:		, F		Start Stop		
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr										
D2561	Rev	v B			-							
Waterjet FLOW CNC Waterje	et	FLOW WATER JET Memo 1-Cut as per Deburr if ne	Dwg D2561 □Dwg Rev: cessary	0.00 0.00 □Prog Rev:	<u>\$</u> []2-				[<u> </u>	i-11 -11	49
QC Quality Control		QC2- Inspect parts off m	achine FAI/FAIB	0.00	·				1	& C	i-((-11	
120		QC8- Inspect parts - seco	and check	0.00				49				Joseph Comment
QC		Memo		0.00								

Quality Control

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CH			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
	:									,		
Part No	:	PAR #:	Fault Cat	egory:	NCR:	Yes N	lo DQ	A:	_ Date: _			
	R	esolution:	Dispositi	on:	_ QA: I	WC Clo	sed:		Date: _			
NCR:		\	WORK ORE	DER NON-CONFORMA	ANCE	(NCR)						
DATE	STEP	Description of NC			Section B			cation	Approval	Approval		
- JAIL	J	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector		
						•						
]									
										<u></u>		

Work Order ID 53616

November 10, 2009 2:19:04 PM

В

Lug



Page 2

Item ID:

D2561

Revision ID:

Item Name:

Start Date:

11/10/09

Required Date: 11/13/09

Start Qty: 60.00 Req'd Qty: 60.00



Accept

Date:

Draw

Rev.

Setup Start



Stop

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling: SPC (Y/N): Date:

Draw

Number

Customer:

Cust Item ID:

Plan

Code

Start Run

Reject

Qty

Reject

Number

Stop

Insp.

Stamp

Sequence ID/ Work Center ID

130

Small Fab Small Fab

Small Fab

Operation

Description

QC:

Memo

Deburr, no sharp edges

Set Up/ **Run Hours**

0.00

0.00

140

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Accept

Qty

150

Packaging

Packaging

Identify as per dwg & Stock Location: WH

Memo

0.00

0.00

49 \$ 1/2 09.11.11

Dart Aerospace L	Lta
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W/O:			WORK ORDER CHANGES								
DATE	STEP	PR	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector		
									,		
Part No	:	PAR #:	Fault Categ	jory:	_ NCR: Yes	No DQA		Date: _			
	Res	olution:	Disposition	:	QA: N/C CI	osed:		Date: _			
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NCR	1)		U-140-0-044-17			
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descr		Section B ption Sign & Date		ation n C	Approval Chief Eng	Approval QC inspector		
·			Chief Eng	Chief Eng	Date						
									:		

Work Order ID 53616

November 10, 2009 2:19:04 PM



Page 3

Item ID:

D2561

Revision ID: В

Item Name: Lug

Start Date:

11/10/09

Start Qty: 60.00



Accept



Setup Start

Stop



Required Date: 11/13/09

Req'd Qty: 60.00

Cust Item ID: Customer:

Draw

Reference:

Approvals:

Process Plan:

QC:

Date:

Date: **Tooling:**

SPC (Y/N):

Date:

Date:

Start Run

Stop



Sequence ID/ Work Center ID

160

Operation Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/ **Run Hours**

0.00

Number Rev.

Draw

Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Quality Control

0.00

Dart Aerospace Ltd

-											
		WORK ORDER CHANGES									
STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
							1				
:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DG	A:	Date: _				
Re	solution:	Disposition	on:	_ QA: N/C (Closed: _		Date:				
		WORK ORE	ER NON-CONFORM	ANCE (NC	R)						
STEP	Description of NC					ication	Approval	Approval			
	Section A	Chief Eng	Action Description Chief Eng	-	1 350	tion C	Chief Eng	QC Inspector			
								!			
							<u> </u>				
		:PAR #: Resolution:	PAR #: Fault Cate Resolution: Disposition WORK ORD STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORM STEP Description of NC Section A Section A Section Description	STEP PROCEDURE CHANGE By	STEP PROCEDURE CHANGE By Date Part	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr :PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A			

Picklist Print

November 10, 2009 2:19:03 PM

Work Order ID: 53616

D2561RevB Parent Item:

Parent Item Name: Lug

Comments:



Start Date: 11/10/09

Required Date: 11/13/09

Page 1

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
M6061T6B0,250X06.00		Purchased	No			100	f	11.2674	23.1600			



6061-T6 Bar .250 x 6.00



B9-11-11

Warehouse Location	Loc Oty	Loc Code		frice)
Main Warehouse				(47)
MAT	11.2674		<u> </u>	
108462	2		None	
10925	3		NOVE	•
110913	6.2674		110913	

Dart Aerospace Ltd

								
W/O:		100	WC	RK ORDER CHANG				
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty Approval Chief Eng / Prod Mgr	Approval QC Inspector
		1						
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA :	Date: _	
Resolution:		Disposition	n:	_ QA: N/C CI	osed:	Date: _		
NCR:			WORK ORD	R NON-CONFORMA	NCE (NCR)		
DATE	STEP	Description of NC		· · · · · · · · · · · · · · · · · · ·			tion Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Date	Section	C Chief Eng	QC Inspector
				•				
]	1 1		1		1 .		1	

DART AEROSPACE LTD	Work Order:	3616
Description: Lug Rlate	Part Number:	D2561
Inspection Dwg: D2561 Rev: B		Page 1 of 1

	FIRST	ARTICLE I	NSPECT	ION CHI	ECKLIST		
	X	First Art	icle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
0.500	+/-0.010	,497	7				
2.525	+/-0.010	2,536	y				
3.975	+/-0.010	3.984	8				
Ø0.257	+0.005/-0.000	P2G.	¥				
4.525	+/-0.010	4.536	Ø				
5.025	+/-0.010	P60.2	~				
0.25	+/-0.030	126-	> 0				
					·		
,							
ر م <u>م</u>				1			
Measured by:	rB.	Audited by:			Prototype Appre	oval:	N/A
Date:	9-11-1	Date:	19-11.	7		Date:	

Rev	Date	Change	Revise	d by	Approved
Α	04.01.21	New Issue	KJ/RF	۸۸	
В	09.05.21	Dimensions updated	KJ ^c	**	
				<i>'</i> ()	



DESIGN	DRAWN BY		EROSPACE LTD RNATIONAL AIRPORT, CANADA		,
B WILLIAMS	APPROVED	DRAWING NO.		REV.	8
1731	82	D2561	SHEET 1	OF	
DATE	1	TIME		SCAL	E.
96.04.26		LUG PLATE		1:	:1

